Work Order ID 82707 *82707*

April-05-12 11:18:13 AM

Item ID: D3182-1 **Accept** *N900040100* **Setup** **Start** *NS1*

Revision ID:

Item Name: Hinge **Stop** *NS2*

Start Date: 05/04/2012 **Start Qty:** 8.00 *8* **Cust Item ID:**

Required Date: 12/04/2012 **Req'd Qty:** 8.00 *8* **Customer:**

Reference:

Approvals: **Process Plan:** MLJ **Date:** 12/04/05 **Tooling:** **Date:** **Run** **Start** *NR1*

QC: **Date:** **SPC (Y/N):** **Date:** **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D3182	**Revision Nbr** Rev A								
100 *100* Waterjet FLOW CNC Waterjet 304.105	FLOW WATER JET	0.00	B12-4-7						
	Memo 1-Cut as per Dwg D3182 Dwg Rev: A Prog Rev: A 2-Deburr if necessary	0.00	8						
110 *110* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB	0.00	B-12-4-7						
	Memo	0.00							
120 *120* QC Quality Control	QC8- Inspect parts - second check	0.00							
	Memo	0.00	Jtaylor						

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ______________ **PAR #:** ______ **Fault Category:** ______________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ______________ **Disposition:** ______________ **QA: N/C Closed:** ________ **Date:** ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 82707 *82707*

April-05-12 11:18:13 AM

Item ID: D3182-1 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Hinge **Stop** *NS2*

Start Date: 05/04/2012 **Start Qty:** 8.00 *8*

Required Date: 12/04/2012 **Req'd Qty:** 8.00 *8*

Cust Item ID:

Customer:

Reference:

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:** **Run Start** *NR1*

QC: **Date:** **SPC (Y/N):** **Date:** **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Small Fab Small Fab	Small Fab **Memo** Deburr if necessary	0.00 0.00							
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00							
150 *150* Packaging Packaging	Identify as per dwg & Stock Location:_______ **Memo** *****STOCK IN BASKET CELL*****	0.00 0.00							

SG 12·04·11 (8x)

w/ 148

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** _________ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action Section B					
DATE	**STEP**	**Description of NC** Section A	**Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector

NOTE: Date & initial all entries

Work Order ID 82707

April-05-12 11:18:13 AM

82707

Item ID: D3182-1

Revision ID:

Item Name: Hinge

Accept *N900040100*

Setup **Start** *NS1*

Stop *NS2*

Start Date: 05/04/2012 **Start Qty:** 8.00 *8*

Required Date: 12/04/2012 **Req'd Qty:** 8.00 *8*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** ________ **Date:** ________ **Tooling:** ________ **Date:** ________

QC: ________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________

Run **Start** *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160*	QC21- Final Inspection - Work Order Release	0.00					12/4/12		
QC Quality Control	**Memo**	0.00							

mf 12-04-11

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: _______

Resolution: ____________ Disposition: ____________ QA: N/C Closed: _______ Date: _______

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-05-12 11:18:17 AM

Work Order ID: 82707

82707

Parent Item: D3182-1

D3182-1

Parent Item Name: Hinge

Start Date: 05/04/2012 **Required Date:** 12/04/2012

Start Qty: 8.00 **Required Qty:** 8.00

Comments: IPP A03.01.29New issueKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA *M304S11GA* 304/316 0.125 Sheet		Purchased	No			100	sf	26.3900	0.0596 **	0.501895			

B12-4-7

(10)

Location	Loc Qty	Loc Code
MAT020	26.39	
121070	26.39	

121070

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W/O:	WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ______________ **PAR #:** ______ **Fault Category:** ______________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ______________ **Disposition:** ______________ **QA: N/C Closed:** _________ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action Section B					
DATE	**STEP**	**Description of NC** Section A	**Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	82707
Description: Hinge	Part Number:	D3182-1
Inspection Dwg: D3182 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.718	+/-0.010	3.721	2		V 1BC2	
Ø0.257	+0.006/-0.001	.257	2		V	
2.304	+/-0.010	2.306	2		V	
R0.125	+/-0.010	.125	2		V	

Measured by:	B
Date:	12-4-7

Audited by:	[signature]
Date:	7/04/09

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.12	New Issue	KJ/JLM	
B	08.01.16	3.718 was 3.178	KJ/EC/DD [signature]	[signature]

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

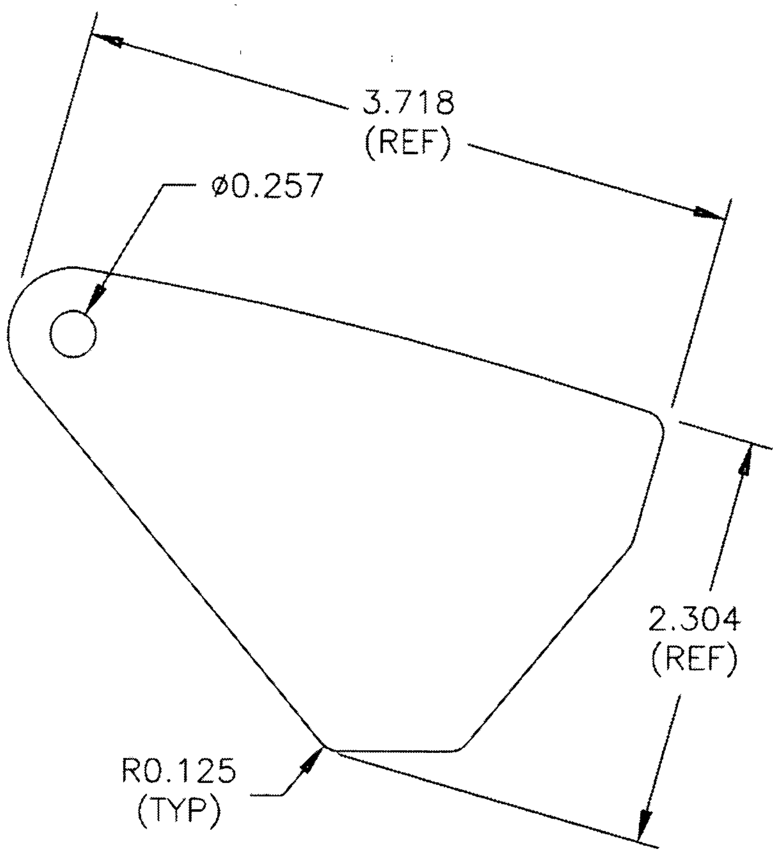
NOTE: Date & initial all entries

DART

QA COPY ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3182	REV. A SHEET 1 OF 1
DATE 03.01.21		TITLE HINGE	SCALE 1:1
A	03.01.21	NEW ISSUE	

RELEASED 03.01.21



D3182-1 HINGE

1) MACHINE D3182-1 PER DART DWG "D3182-1.DWG"
2) MATERIAL: AISI 304/316 SS SHEET 0.125 THICK
   (REF DART SPEC. M304S11GA)
3) FINISH: NONE
4) BREAK ALL SHARP EDGES 0.005 TO 0.010
5) TOLERANCES ARE PER QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82707 MCJ
12/04/05

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action Section B					
DATE	**STEP**	**Description of NC** Section A	**Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector

NOTE: Date & initial all entries